



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2573
Job Sheet 165394



Part No: D2573

Job Qty: 12 ea

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV F IPP: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D2573 Saddle, Aft, Out	DWG REV F IPP: I As Per RevE 06-01-27 JLM		0.000	
D6101-007 Saddle Billet	DWG REV B		0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	12 Ea	10/27/17	0.00	0.00	Start up container	
100	CNC Vertical Machining	12 pcs	10/30/17	1.01	24.54	HAAS 1	
110	Mill Conv	12 pcs	10/30/17	0.00	2.66	Mill Conv 1	
120	QC	12 pcs	10/30/17	0.00	0.00	QC2	
130	QC	12 pcs	10/30/17	0.00	0.00	QC8	
140	HandFinish	12 pcs	10/30/17	0.00	0.56	HandFinish1	
150	Powdercoat	12 pcs	10/31/17	0.00	0.46	Powdercoat1	
160	QC	12 pcs	10/31/17	0.00	0.00	QC3	
170	Packaging	12 pcs	10/31/17	0.00	0.00	Packaging3	
180	QC21-SA	12 Ea	10/31/17	0.00	0.00	QC21	

Part Op 100 - Program Batch No. B165394

Descriptions: 110 - Machine keyway as per dwg D2573 & D2574

150 - START TIME: 10:05 O.V.T: 8:30 FINISH: 11:05 M 1380H.

Job Allocations

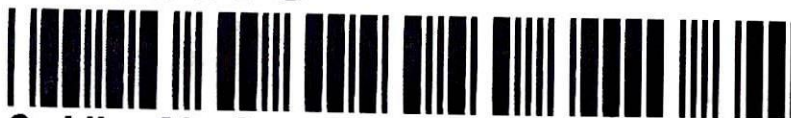
Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-007	12	0	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S005573

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Saddle, Aft, Out

PART NO:	D2573
Revision:	
Operation:	Start up Operation
Quantity:	12
Change No:	

Mfg Date: 11/03/17

Job No: 165394

Work Order ID 165394

Monday, August 21, 2017 2:55:19 PM

165394

page 1

Item ID: D2573

Accept

N900040100Setup Start ***NS1**

Revision ID:

Stop ***NS2**

Item Name: Saddle, Aft, Out

Start Date: 8/22/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/31/2017 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: AUG 22 2017

Tooling:

Date:

Run Start ***NR1**

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2**Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp
Star

Draw Nbr

Revision Nbr

D2573

F

100

2.21

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

8.84

HAAS CNC vertical machine #1

Program Batch No. **BK5394**Double check by: **F.K.**

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

FM DAS
44
9-89
17-11-**12**

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

1.08

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

FM DAS
44
9-89
17-11-**12**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐	
Misidentified ☐	Past Due ☐																																																														

165394

Monday, August 21, 2017 2:55:20 PM

N900040100

Setup Start *NS1*

Stop *NS2*

12

Cust Item ID:

Start Date: 8/22/2017 **Start Qty:** 12.00

Required Date: 8/31/2017 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

120

QC

Memo

0.12

Quality Control

0.00

130

QC

Memo

0.24

Quality Control

0.00

140

HandFinish

Memo

1.03

Hand Finishing

Work Order ID 165394

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165394

Page 3

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft, Out
Start Date: 8/22/2017 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 8/31/2017 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.24				_____	_____	_____	_____
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.12				_____	_____	_____	_____
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.12				_____	_____	_____	_____

Monday, August 21, 2017 2:55:20 PM

Item ID: D2573

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle, Aft, Out

Stop *NS2*

Start Date: 8/22/2017 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 8/31/2017 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

**Set Up/
Run Hours****Tool ID****Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

1.20

Quality Control

Picklist Print

Monday, August 21, 2017 2:55:22 PM

Page 1

Work Order ID: 165394

165394

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft, Out

Start Date: 8/22/2017

Required Date: 8/31/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	10.0000	1	12			
D6101-007									**				
Saddle Billet													

DAS
44
9-89

17-11-4

Location

Loc Qty

Loc Code

MAT041

10

164013

10

165018

2

10

DART AEROSPACE LTD	Work Order: 165894
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.494	.501	.500	.500		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.498	.503	.504	.503		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.565	.569	.568	.569		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.368	1.368	1.368	1.368		
N	2.495	2.505		2.499	2.499	2.499	2.499		
O	4.119	4.129		4.123	4.123	4.123	4.123		
P	0.115	0.135		0.125	.130	.130	.130		
Q	0.115	0.135		0.124	.124	.124	.123		
R	0.240	0.260		0.253	.252	.254	.252		
S	0.115	0.135		0.1265	.126	.126	.126		
T	0.178	0.198		0.1875	0.1875	0.1875	0.1875		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.237	.240	.240	.241		
W	0.115	0.135		.124	.125	.124	.125		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.369	.366	.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		.627	.629	.628	.628		
AC	0.053	0.073		0.065	0.065	0.065	0.065		
AD	0.240	0.260		0.250	.251	.250	.251		
AE	1.500	1.520		1.5145	1.510	1.510	1.510		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		0.257	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: FM	DAS
Date: 17-11-4	44

Audited by: MML
Date: 17/11/09

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 165394
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	0.498	0.499	0.499		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.502	.500	.502	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.567	.564	0.563		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.123	.124	.123	0.123		
R	0.240	0.260		.252	0.252	.253	0.254		
S	0.115	0.135		.125	.129	.127	0.129		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	0.241	0.237	0.239		
W	0.115	0.135		.124	0.123	0.129	0.132		
X	0.308	0.313		.312	0.312	0.312	0.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	0.364	0.362	0.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	0.625	0.627	0.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.251	.250	0.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.250	0.252	0.252	0.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: 44
Date: 17-11-09

Audited by: M. L.
Date: 17/11/09

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 165399
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				* 9	* 10	* 11	* 12		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.499	0.500	0.500		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.502	0.502	0.501	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.564	0.567	0.567	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.130	0.130	0.130	0.130		
Q	0.115	0.135		0.123	0.123	0.123	0.123		
R	0.240	0.260		0.254	0.254	0.253	0.253		
S	0.115	0.135		0.129	0.128	0.129	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.239	0.239	0.236	0.240		
W	0.115	0.135		0.129	0.129	0.130	0.130		
X	0.308	0.313		0.312	0.312	0.312	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.361	0.360	0.361	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.627	0.626	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.251	0.252	0.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.265	0.265	0.265	0.265		
AH	0.240	0.260		0.245	0.247	0.247	0.247		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	
Date:	

Audited by:	Sum L
Date:	12/11/09

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

